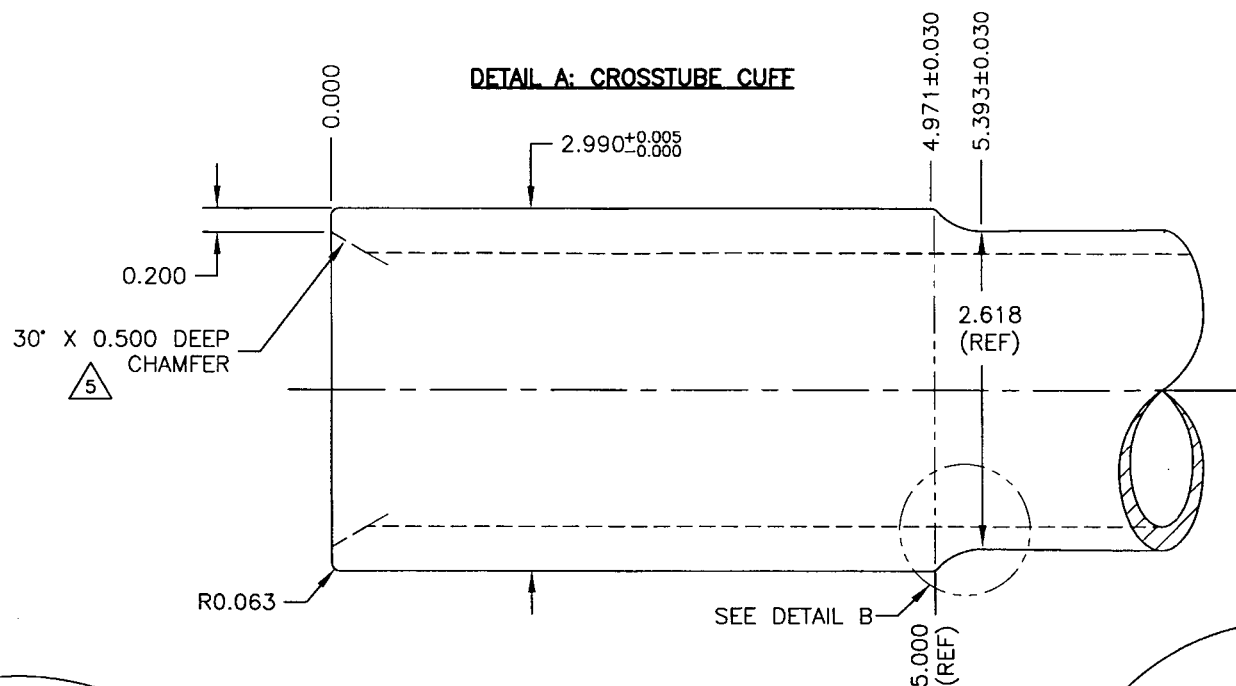




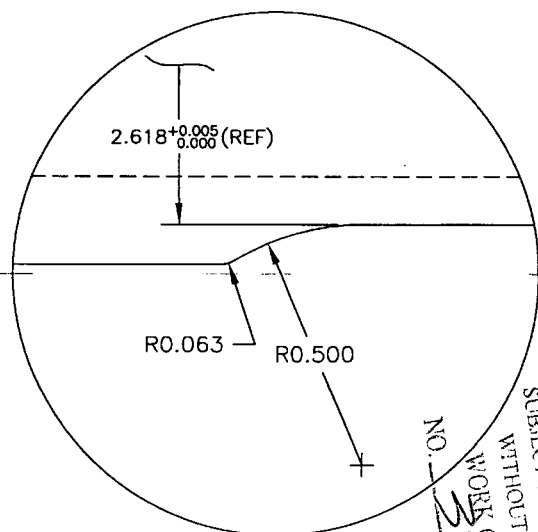
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07-04-244  
REF ECN 889

**DETAIL A: CROSSTUBE CUFF**

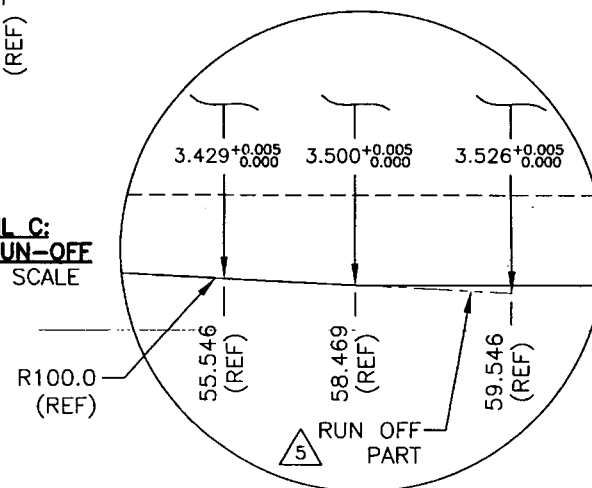


SEE DETAIL B

**DETAIL B: CUFF  
TRANSITION  
SCALE 4:1**



**DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE**

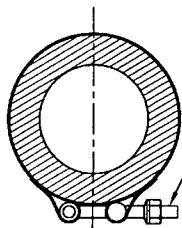
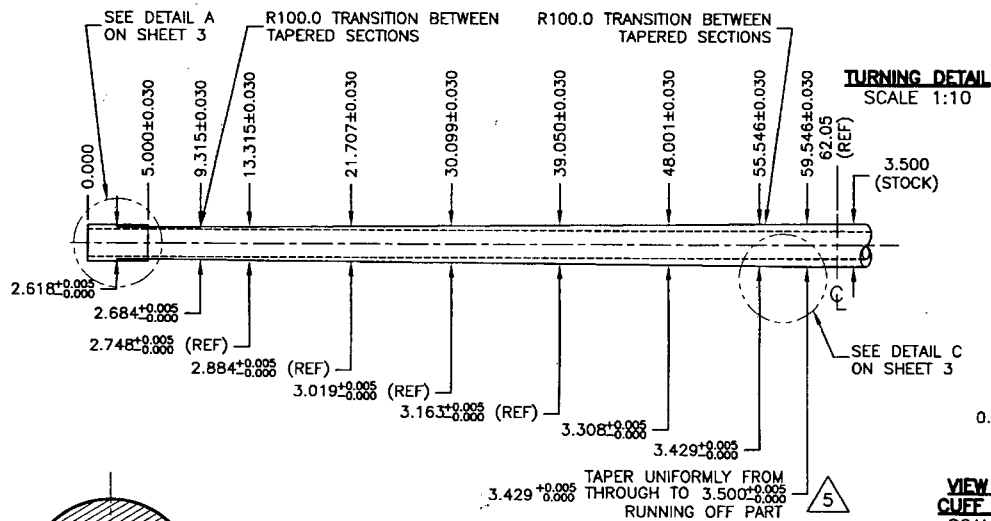
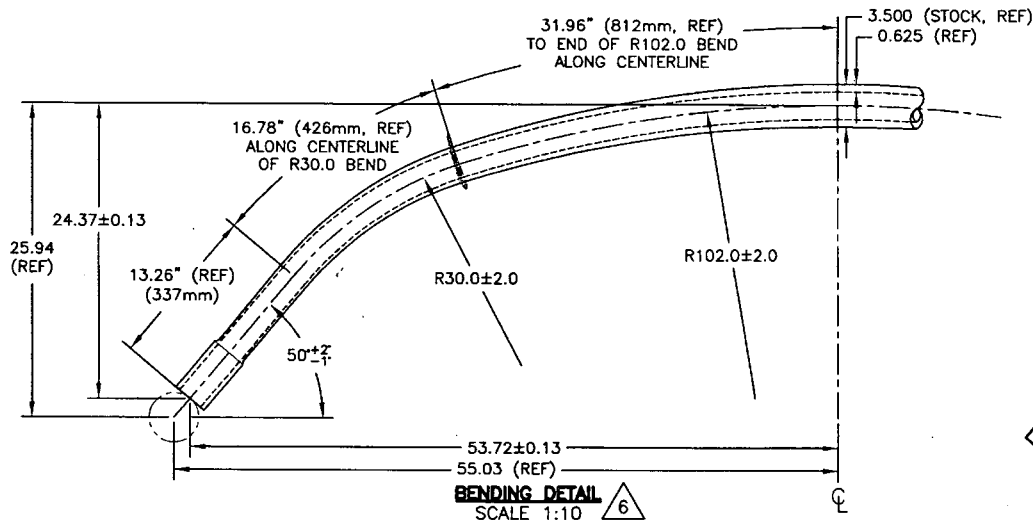


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WORK ORDER  
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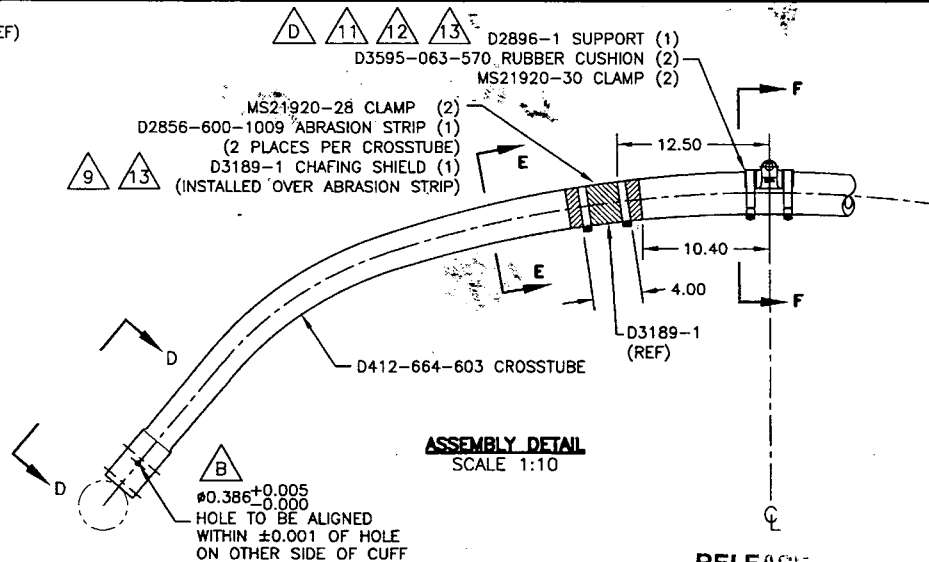
DESIGN PH	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED J	APPROVED [Signature]	DRAWING NO. D412-664-243	REV. D SHEET 3 OF 3
DATE 07.03.09	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE 1:1	



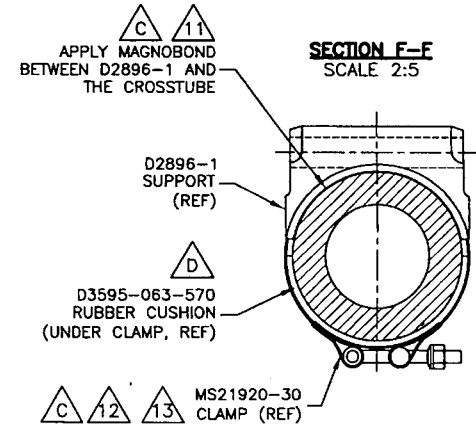
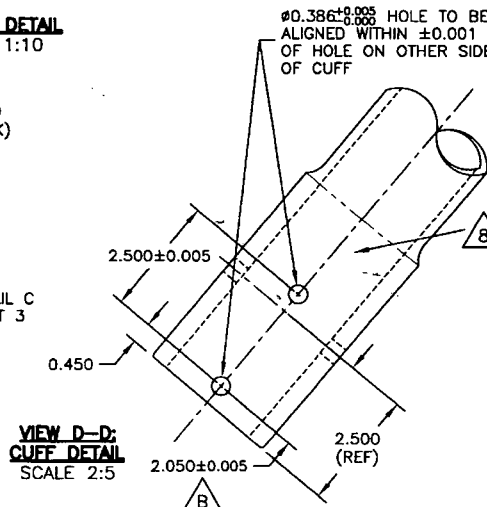
**SECTION F-F**  
SCALE 2:5

MS21920-28 CLAMP (REF)

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RELEASE  
07 04 24



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		07.03.09		D412-664-243	SHEET 2 OF 3
				TITLE	SCALE
				CROSSTUBE ASSEMBLY (412 HI AFT)	1:10

**DART**

DESIGN <b>PH</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>GP</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D412-664-243	REV. D SHEET 1 OF 3
DATE 07.03.09		TITLE CROSSTUBE ASSEMBLY (412 HI AFT) NTS	
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30	
D	07.03.09	REMOVE D2732-058, CHANGE TO D3595-063-570	

**RELEASE**07.04.24 **[Signature]**

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
2	D3595-063-570	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129  
FINISHED LENGTH = 124.09±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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WORK ORDER  
NO. **37177**

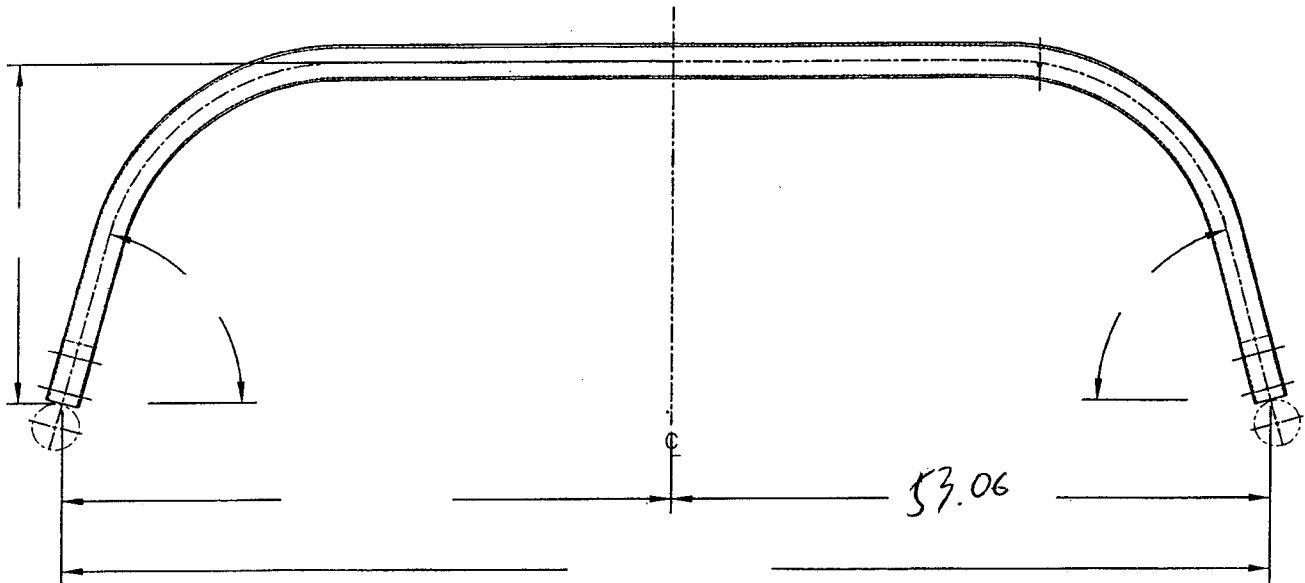
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~~08-02-05~~ 08-02-05

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	37177
<b>Description:</b> Crosstube High Aft (412)		<b>Part Number:</b>	D412-664-203
<b>Inspection Dwg:</b> D412-664-243 <b>Rev:</b> D		Page 1 of 1	

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	37177
<b>Description:</b> Crosstube Assembly (412 High Aft)	<b>Part Number:</b>	D412-664-243
<b>Inspection Dwg:</b> D412-664-243 <b>Rev:</b> D		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.689				
	2.748	+0.005/-0.000	2.753				
	2.884	+0.005/-0.000	2.889				
	3.019	+0.005/-0.000	3.024				
	3.163	+0.005/-0.000	3.168				
	3.308	+0.005/-0.000	3.313				
	3.429	+0.005/-0.000	3.434				
	2.990	+0.005/-0.000	2.995				
	2.618	+0.005/-0.000	2.623				
	0.200	+/-0.010	.200				
	R0.063	+/-0.010	.063				
	R0.500	+/-0.010	.500				
	4.971	+/-0.030	4.971				
SIDE B	2.684	+0.005/-0.000	2.689				
	2.748	+0.005/-0.000	2.753				
	2.884	+0.005/-0.000	2.889				
	3.019	+0.005/-0.000	3.024				
	3.163	+0.005/-0.000	3.168				
	3.308	+0.005/-0.000	3.313				
	3.429	+0.005/-0.000	3.434				
	2.990	+0.005/-0.000	2.995				
	2.618	+0.005/-0.000	2.623				
	0.200	+/-0.010	.200				
	R0.063	+/-0.010	.063				
	R0.500	+/-0.010	.500				
	4.971	+/-0.030	4.971				
	124.09	+/-0.020	124.095				

<b>Measured by:</b> RO	<b>Audited by:</b> JF	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/02/24	<b>Date:</b> 08/02/25	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.08	Tolerance updated for dimension 4.971	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/4/2008 11:26:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 37177

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*D 08/04/04*

Job Completion



*umf*

*08-04-04*

*u*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:26:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 37177

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt  
Batch: \_\_\_\_\_

33.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt  
Batch: \_\_\_\_\_

34.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)  
Washer  
Batch: \_\_\_\_\_

35.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Nut  
Batch: \_\_\_\_\_

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

\*\*\*\*\*Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date  
\*\*\*\*\*

Time & date of packaging: \_\_\_\_\_

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:26:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 37177

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3189-1 Chafing Shield

27.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp

28.0

MS2192030

clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch:

29.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-203

1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond Batch:

Expiry Date:

2-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/4/2008 11:26:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 37177

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

21.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

22.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

23.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0492 sf(s)/Unit Total : 0.0492 sf(s)

Rubber Cushion (per sq ft)

.630" x5.70" x2pcs

Batch: \_\_\_\_\_

24.0

D2856600

Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600(Cut to 10.090") Abrasion Strip \_\_\_\_\_

25.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)


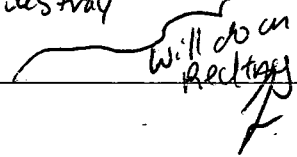


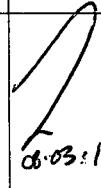
Pick:

Qty Part number Description Batch

1 D2896-1 Support \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-644-203 PAR #: NA Fault Category: Prod/Landing Gear NCR: Yes/No DQA: JD Date: 01/03/12  
 QA: N/C Closed: JD Date: 08/03/12

NCR: 37177		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
080305	12.0	Tube over bent on the I side, ALOT. R.C. Additional program to adjust the cuff, over bent the tube & operator error.	 08/03/12	- Keep tube for interior polish testing with new tool. <hr/> - scrap & destroy  Will do on Rectifying	JD 8-3-12	 08-03	 08/03/12	 08-03-10

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:26:15 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 37177

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

*R 8-34* *(P40)*

13.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038 Or

Issue P/O: \_\_\_\_\_ LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:26:15 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 37177

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA166

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

3- Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243

Cuff(Donot engrave on outside of tube)

Inside of

24 08/02/24

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

24 08/02/24

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 08/02/25

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

AWM 8-2-26

1-Polish entire outside surface of crosstube

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 8-2-26

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

AWM 8-2-26

Chemical Conversion Coat as per QSI 005 4.1

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect work & Chemical conversion Coat

DP 8-2-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:26:15 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HIGH AFT X-TUBE 412  
 Job Number : 37177  
 Estimate Number : 10559  
 P.O. Number :  
 This Issue : 2/4/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D412664203  
 First Issue : / / Type : LANDING GEAR Drawing Number : D412-664-243 REV D  
 Previous Run : 36063 Drawing Revision : D  
 Material :  
 Due Date : 2/28/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 08 02 04  
 Comment : Est Rev:E 04.02.16 Reformat; Added D3189-1 K/DS  
 Est Rev:F 06-03-29 Remove Coments on Pick List JLM  
 Est Rev:G 06.12.08 per ECN 886 EC  
 Est Rev:H 07-04-30 As per Rev D JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 006

08.02.12

2.0 D6009129 Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6009-129 Crosstube B 32305

Check OD = 3.500"; ID = 2.250"

08/02/20

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA166

2-Turn first side as per Folio FA166

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

08/02/24

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

08/02/24